



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2594-1

Job Sheet 213874



Part No: D2594-1

Job Qty: 100 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/20

Job Tracking No:

Due Date: 10/26/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	100 pcs	10/24/20	10/24/20	0.01	2.87	Hardinge - 1		P. 10/16/20
110	QC 2	100 pcs	10/24/20	10/24/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		P. 10/16/20
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S306948



Part: D2594-1

Job No: 213874

Serial No/Batch: S306948

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/16/20

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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120 QC 8	100 pcs	10/24/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	De 20-10-18
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
130 Handfinish - 1-1 Chemical- B4B	100 pcs	10/24/20	0.00 0.93	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 -	

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					B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
135	Powdercoat - 1 White Gl(A)- B4B <i>M 254469.</i>	100 pcs	10/26/20	0.00 0.63	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	<i>20-10-22</i>
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
150	QC 3	100 pcs	10/26/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	<i>OCT 26 2020</i>
					QC 3 - 87	
					QC 3 - 47	
160	Packaging 3-1 - Stock - B4B	100 pcs	10/26/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	FP-001 2010-10-20
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170	QC 21 - SA	100	10/26/20	0.00 0.00	QC 21 - SA - 21	DAS 21 0-82
		pcs			QC 21 - SA - 70	
						OCT 7 6 2020
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QC 21 - SA - 9

QC 21 - SA - 77

QC 21 - SA - 28

Part Op 100 - (Hardinge) 1-Make as per Dwg D2594-1 and Folio FA262.

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Chemical Conversion Coat per QSI005 4.1)

135 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME:

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location:) LOCATION : FP001

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	5.2100 ft (.0521 ea) <i>057ea</i>	100-Hardinge - 1	<i>S 306823</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.625	5	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches ± 0.005	0.065 0.055		
2	Plug	0.500inches ± 0.010	0.510 0.490		
3	Plug	0.625inches ± 0.010	0.635 0.615		
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428		
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088		
6	Plug	0.045inches + 0.000 - 0.002	0.045 0.043		

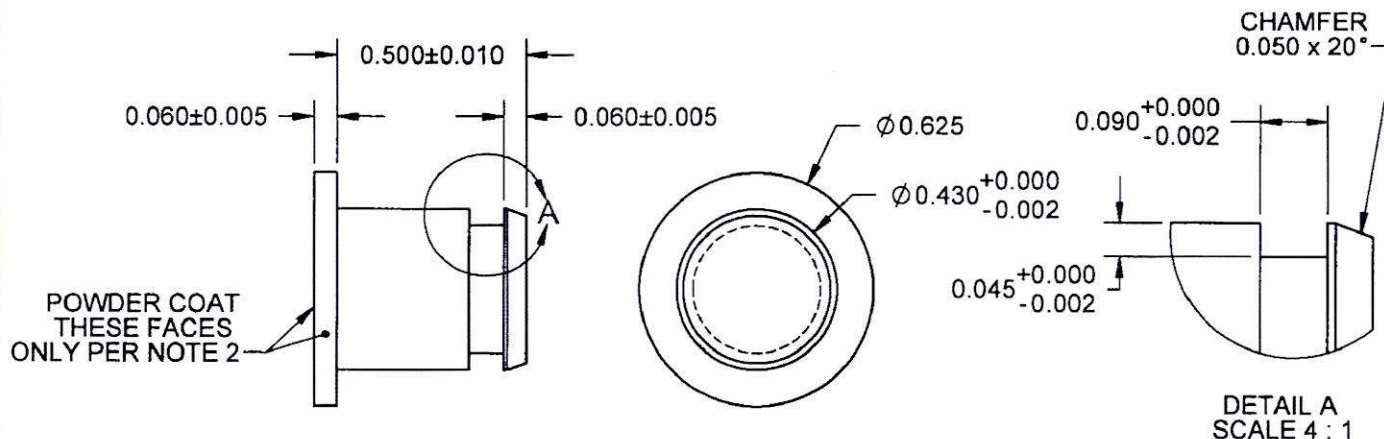
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DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG		SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

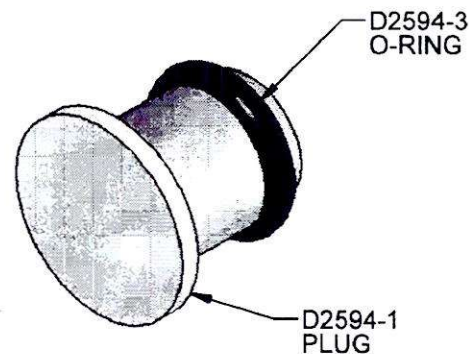
D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213874

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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